

Date:
User:Monday, 22/12/2008 3:05:24 PM
Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ACCESS PANEL ASSEMBLY	
Job Number :	44235	Part Number :	D3259041	
Estimate Number :	12948	Drawing Number :	D3249 REV A1	
P.O. Number :		Project Number :	N/A	
This Issue :	22/12/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A1	
First Issue :	/ /	Type :	SMALL /MED FAB	
Previous Run :	43640	Material :		
Written By :		Due Date :	20/01/2009	Qty: 4 Um: Each
Checked & Approved By :	JLD 08.12.23			
Comment :	Est Rev:A New Issue 07-07-19 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Assembly Kit

2.0	D32591	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
panel
Batch: 43771

3.0	D32593	Doubler
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Doubler
Batch: 43772

4.0	D32595	Spacer
-----	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer
Batch: 44774

5.0	D32597	Door
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Door
Batch: 44298 34738

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 44235

Part Number: D3259041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31615

Hinge 9.9"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 9.9"

Batch: 44298

LU

7.0

D32601

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spring

Batch: 43775 3P 34258 5P

LU

8.0

127H5

HALF GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HALF GROMMET

Batch: 105018

LU

9.0

250018C3Y

RIGHT RECEPTACLE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: 100034

LU

10.0

2501W20020C3Y

STUD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

STUD

Batch: 100398

LU

11.0

MS20426AD44

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch: M15541

LU

12.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s)

Rivet, Universal Head

Batch: 15541

LU 9/10/22 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 22/12/2008 3:05:24 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 44235

Part Number: D3259041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet

Batch: 9682

09/01/22 (4) (4) (4)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3259-041 as per Dwg D3259.
Note: Keep .040" Gap all around door.

FF 09/01/27 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/27 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: 182

09/01/27 50 (4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/28

Job Completion

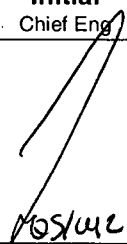
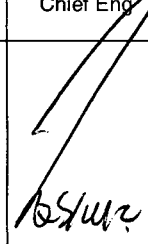
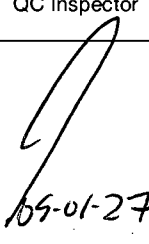


09.01.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

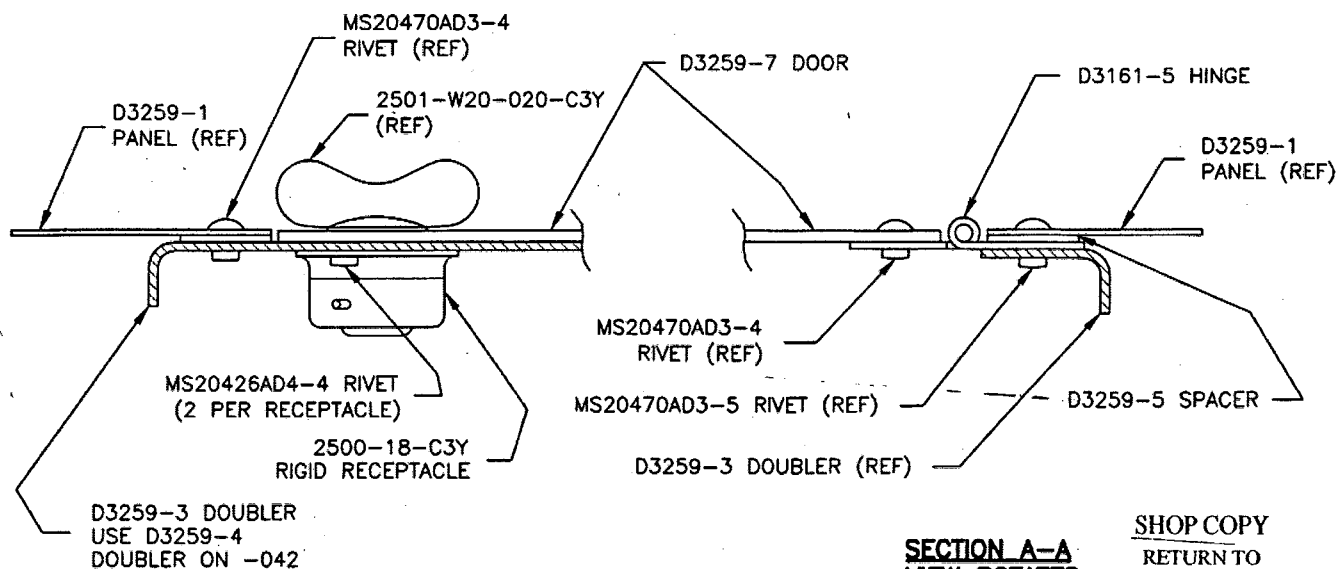
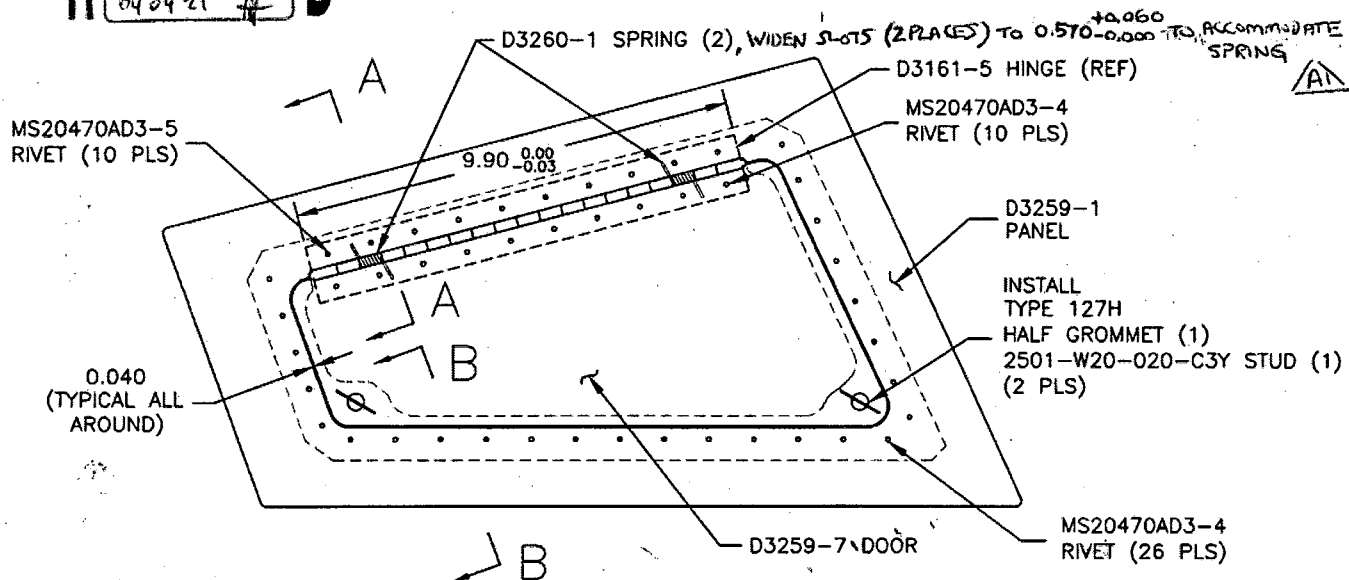
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/26	14	Hole in (D31615) Hinge Too large for Rivet R.C. moves when transfer Drilling. Human error.		Scrap + Replace D31615 # B43859 Qty 1	09/01/26 FF			

NOTE: Date & initial all entries



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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4	
A		04.02.25		NEW ISSUE	
AI	CP	04.08.11		WIDEN SLOTS TO ALLOW OPERATION OF SPRING	

RELEASED
040421



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 14235

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)

D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

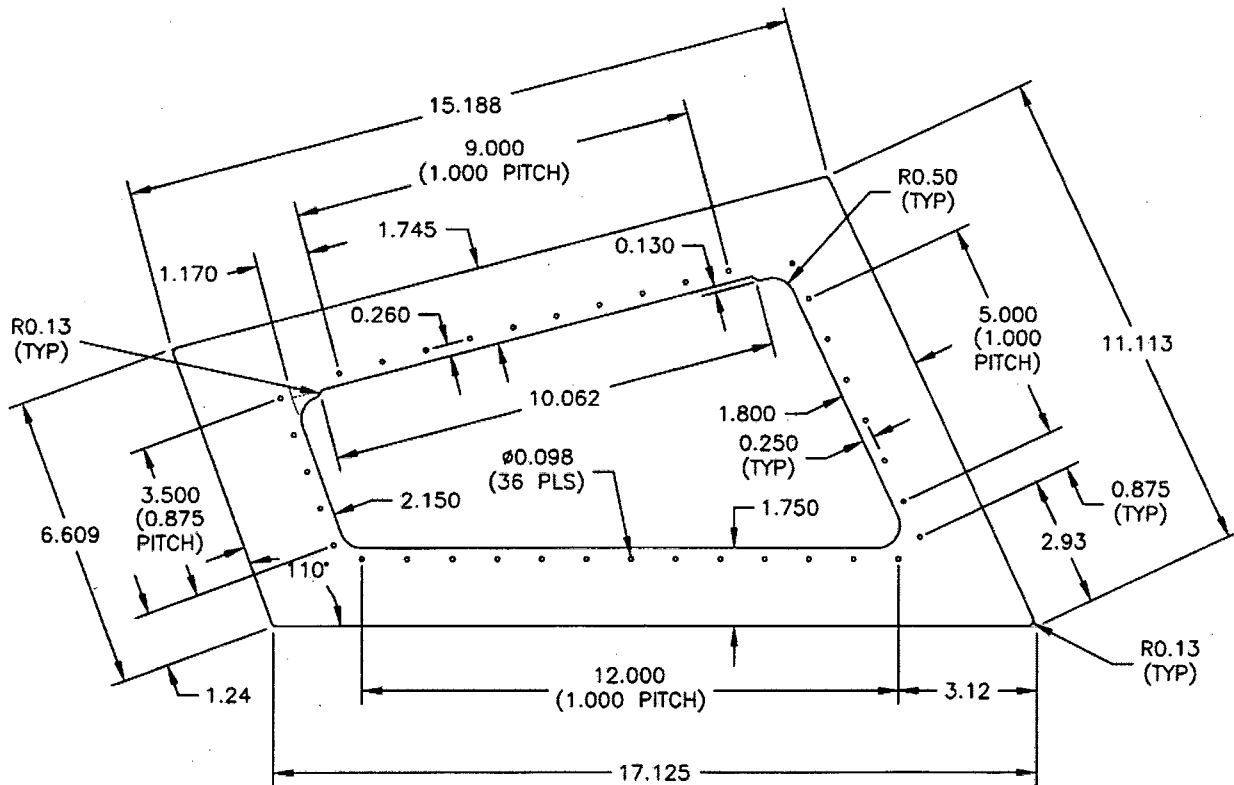
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

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NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

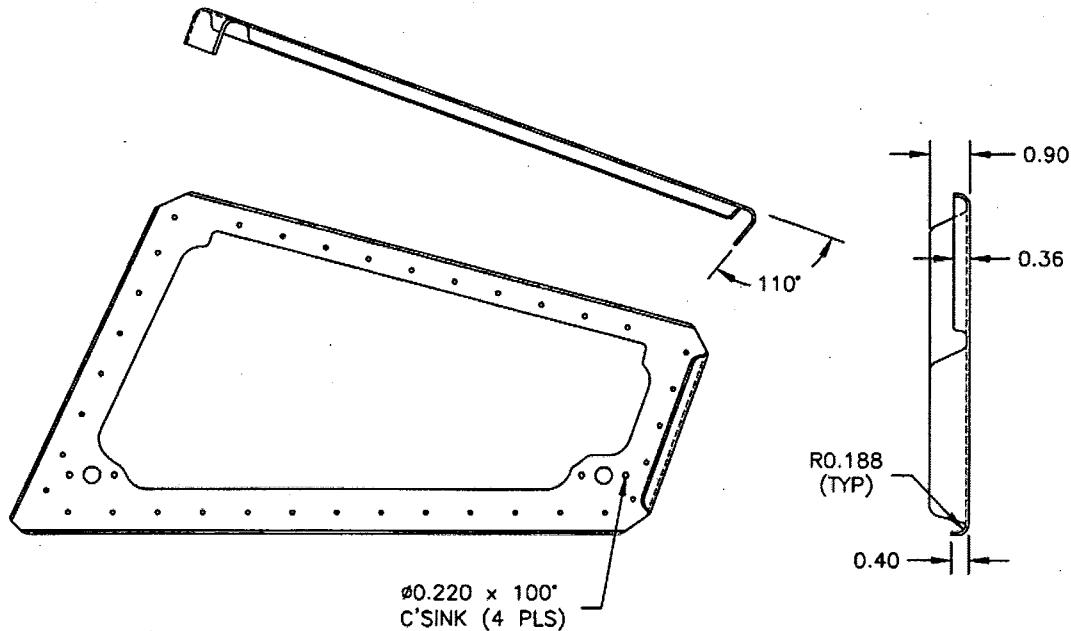
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 [Signature]**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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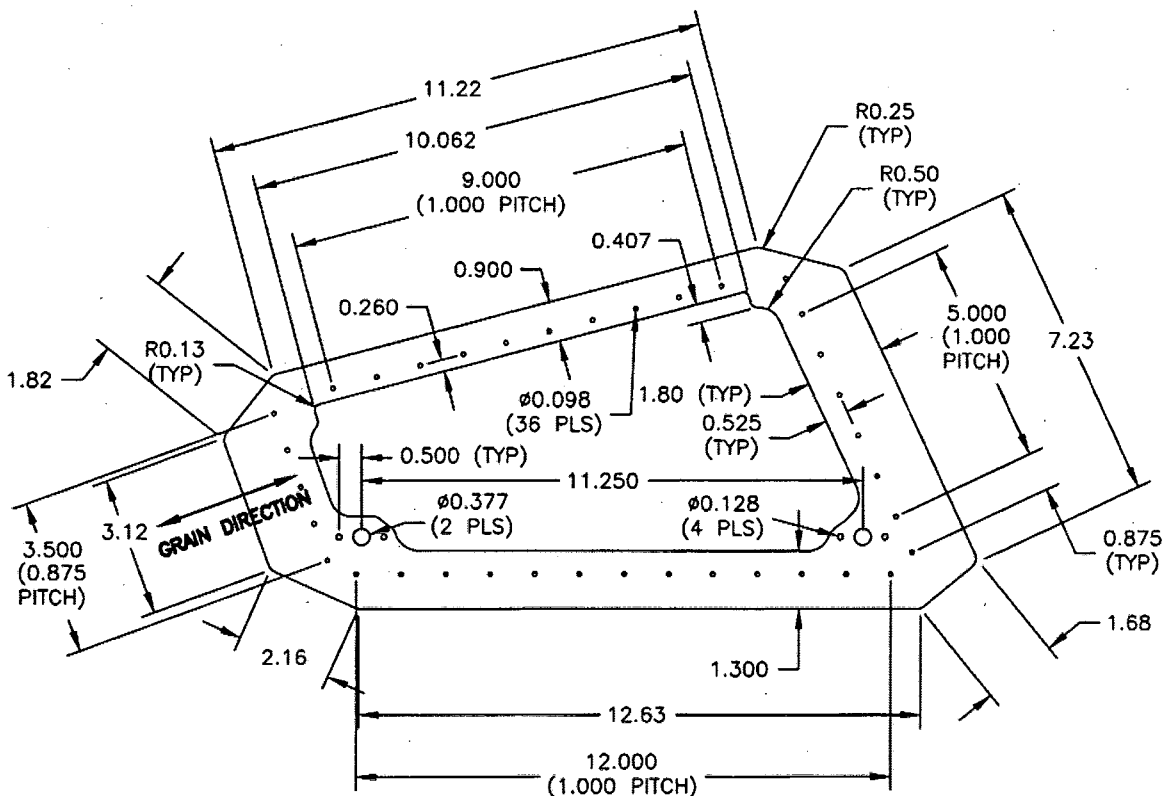
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04 14 [Signature]



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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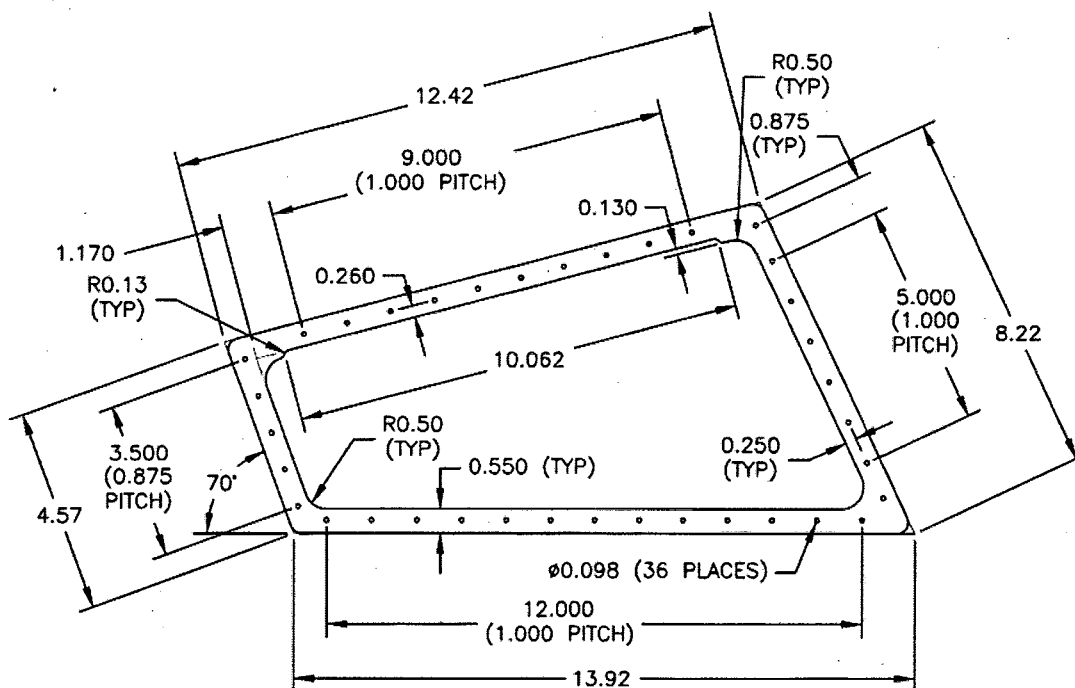
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-5 SPACER

(0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 UNCONTROLLED COPY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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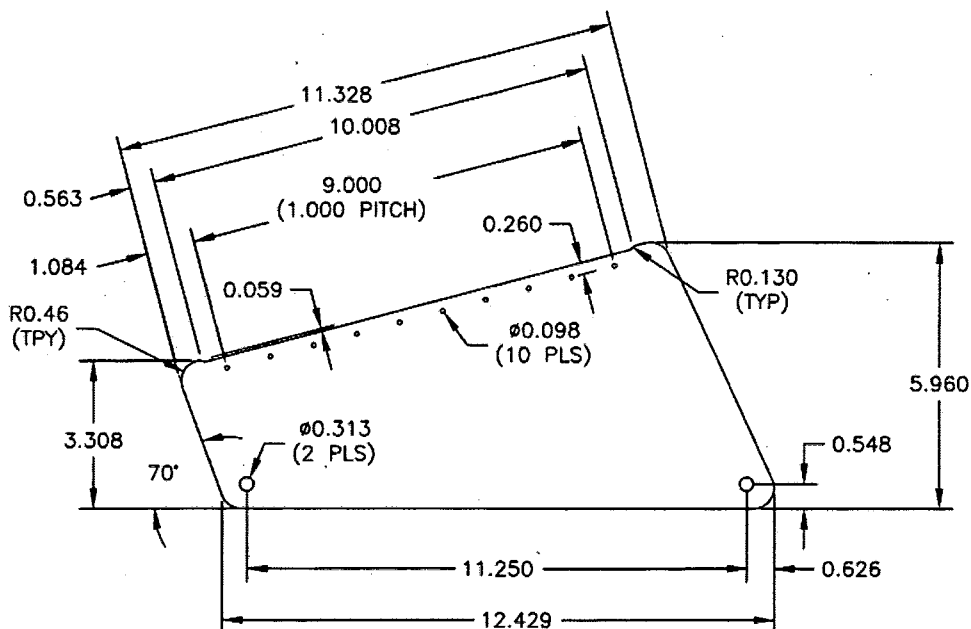
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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